

Work Order ID 62849

Tuesday, October 12, 2010 11:42:03 AM



Page 1

Item ID: D350-607-043A

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Start Date: 10/12/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 10/22/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

H

Date:

10/10/12

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D350-607-1

A

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPPD350-607-043A CHG001

8 u 03/130

ff for BG 11-3-29

110

0.00



Pick Kit

Packaging

Memo

0.00

Packaging

44/3/29

120

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Assemble as per Dwg D350-607
Seal Support Gusset with Sikaflex -291

Batch: *M116 040*

Exp Date: *11/01*

1 0 11/03/29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Page 2

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8 w/03/29

(H)

140

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

11/3/30 SP

150

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

8 w/03/30

(H)

W/O:		WORK ORDER CHANGES					
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Cust Item ID:

Required Date: 10/22/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  Packaging	Packaging	0.00				11/3/30	SD		
Packaging	Memo Identify and pack for shipping as per PPP D350-607-043A Location: <u>Br</u>	0.00							Rec A
170  QC	QC21- Final Inspection - Work Order Release	0.00							11/3/30
Quality Control	Memo	0.00							ME 11-03-30

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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Picklist Print

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Page 1

Work Order ID: 62849

Parent Item: D350-607-043A

Parent Item Name: Heli-Utility-Basket (Automatic Lid Opener)






Start Date: 10/12/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevB: as per dwg revC DD 10.01.18 verified by:EC
per dwg revC DD 10.01.18 verified by:EC
545 DD 10.04.19 verified by:EC
IPP RevC: as
IPP rev:D as per ecn10-

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2728-3 		Manufactured	No			110	Each	0.0000	2	2			
Dart Logo label													
D350-607-241 		Manufactured	No			140	Each	2.0000	1	1			
Basket Clamp Assembly													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				FG022				2					
				61681				2					
D2022-101 		Manufactured	No			110	Each	94.0000	5	5			
Spacer													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST504				94					
				50746				23					
				52325				11					
				61990				60					
D2221 		Manufactured	No			110	Each	0.0000	1	1			
350 Basket Base													
D2258-200 		Manufactured	No			110	Each	12.0000	1	1			
Placard 200lb													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST505				12					
				61760				12					

67712 11/3/30 S

66939

362854 (v1) 11/03/29

69289 11/3/29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 2

Work Order ID: 62849

Parent Item: D350-607-043A


Parent Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Start Date: 10/12/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00


D2530 Manufactured No 110 Each 12.0000 1

 Handle Weldment



66171

[Handwritten signature]

Location	Loc Qty	Loc Code
ST506	12	
60206	2	
61224	10	


D2535 Manufactured No 110 Each 72.0000 2

 Spring



64250

[Handwritten signature]

Location	Loc Qty	Loc Code
ST504	72	
58331	72	


D2537 Manufactured No 110 Each 54.0000 2

 Bushing



65670

[Handwritten signature]

Location	Loc Qty	Loc Code
ST504	54	
59122	12	
59423	12	
62393	30	


D2931 Manufactured No 110 Each 784.0000 2

 Bumper



2 ~

[Handwritten signature]

Location	Loc Qty	Loc Code
ST504	784	
46064	784	

D2989-041 Manufactured No 110 Each 0.0000 1

 Basket Lid Assembly



46064

1362857 (x) 11/03/29

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Page 2

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 3

Work Order ID: 62849



Parent Item: D350-607-043A



Parent Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Start Date: 10/12/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

D2989-043 Manufactured No

110 Each

0.0000

1

1



Basket Lid Assembly

D350-607-143 Manufactured No

110 Each

1.0000

1

1



Automatic Lid Opener Installation



1362860 (x1) M 11/6/29



65172

[Handwritten signature]

Location

Loc Qty

Loc Code

FG032

1

54041

1

AN3-16A Purchased No

110 Each

98.0000

2

2



Bolt



[Handwritten signature]

Location

Loc Qty

Loc Code

ST352

98

114752

98

AN4-13A Purchased No

110 Each

414.0000

2

2



Bolt



114752
116786

[Handwritten signature]

Location

Loc Qty

Loc Code

ST358

414

115159

414

AN4-22A Purchased No

110 Each

201.0000

5

5



Bolt



[Handwritten signature] 11/13/29

Location

Loc Qty

Loc Code

ST359

201

111965

2

114523

99

114784

100

1151523

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 62849

Parent Item: D350-607-043A


Parent Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Start Date: 10/12/2010


Required Date: 10/22/2010

Start Qty: 1.00


Required Qty: 1.00

AN5-17A Purchased No 110 Each 86.0000 4 4

 Bolt


Location	Loc Qty	Loc Code
ST339	86	
114784	46	
115594	40	

MS20600-AD4W3 Purchased No 110 Each 1,569.000 2 2

 Cherry Rivets

Location	Loc Qty	Loc Code
ST321	1569	
107939	822	
111636	747	

AN960JD416 NAS1149D0463J Purchased No 110 Each 24.0000 14 14

 Washer

Location	Loc Qty	Loc Code
ST300	24	
113288	24	

AN960JD516 NAS1149D0563J Purchased No 110 Each 34.0000 4 4

 Washer

Location	Loc Qty	Loc Code
ST	34	
103694	18	
107534	12	
109287	4	

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

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Work Order ID: 62849



Parent Item: D350-607-043A



Parent Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Start Date: 10/12/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

AN960JD8 NAS1149DN832 Purchased No

110

Each

10.0000

2

2



Washer



116887

[Signature]

Location

Loc Qty

Loc Code

ST347

10

105059

10

NAS1515H4 Purchased No

110

Each

97.0000

2

2



Washer



[Signature]

Location

Loc Qty

Loc Code

ST277

97

111294

5

111525

92

MS21042L3 Purchased No

110

Each

2,546.000

2

2



Nut



111828

2

116391

[Signature]

11/13/28

Location

Loc Qty

Loc Code

ST300

2546

114523

49

114784

1497

115835

1000

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 6

Work Order ID: 62849

Parent Item: D350-607-043A

Parent Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Start Date: 10/12/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

MS21042L4

Purchased

No

110

Each

4,122.000

7

7



116188

[Signature]

Nut

Location

Loc Qty

Loc Code

ST300

4122

113422

68

114523

8

114718

16

114784

32

115108

998

115589

1900

115621

1100

MS21042L5

Purchased

No

110

Each

895.0000

4

4



C413/ps @

Nut

Location

Loc Qty

Loc Code

ST139

26

114813

26

ST300

869

115156

369

115594

500

115594

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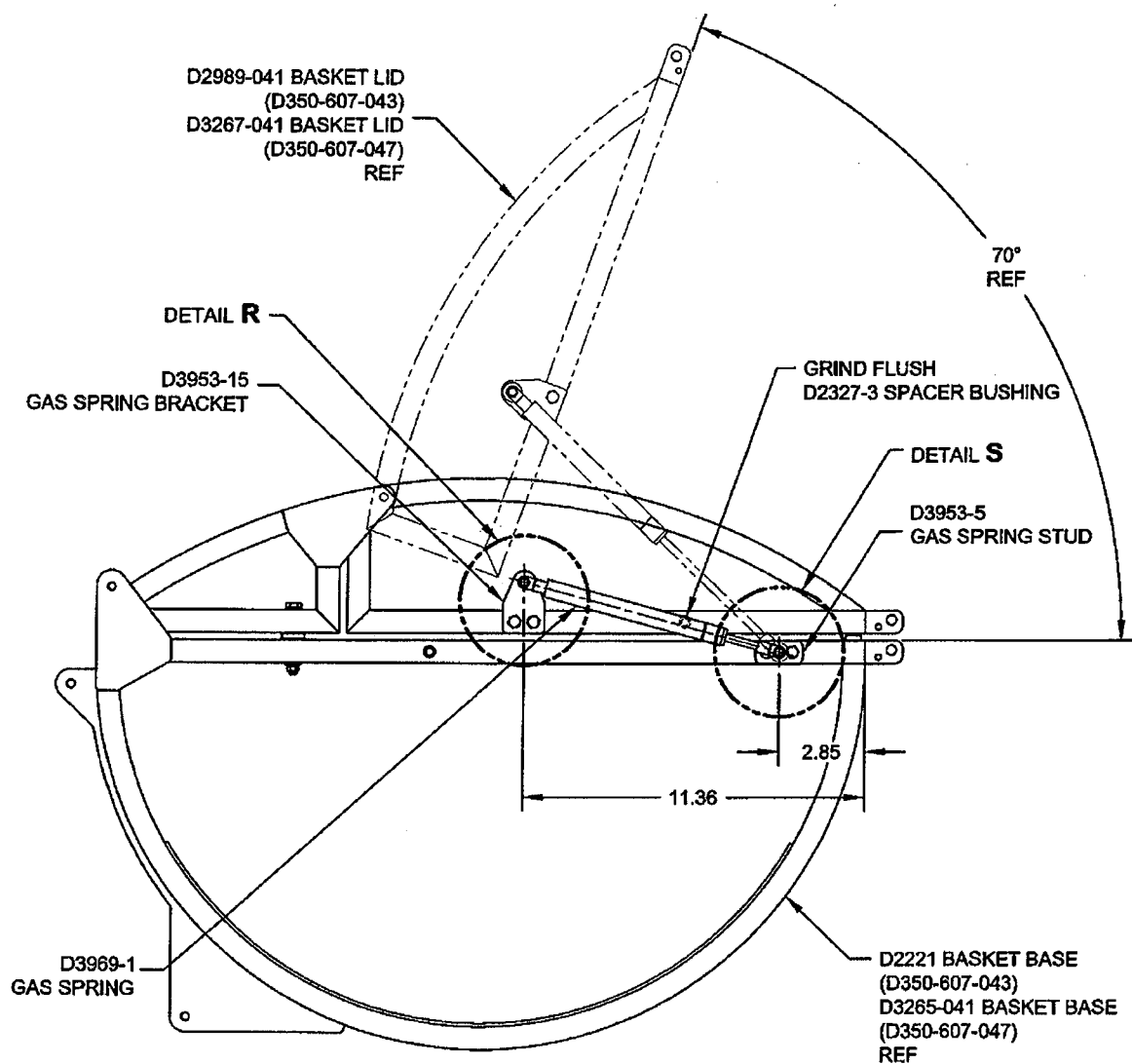
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



SHOP COPY
 PART NO.
 UNCONTROLLED COPY
 SUBMITTAL
 WORK ORDER
 NO. 62849
 2/10/12

D350-607-143 AUTOMATIC LID OPENER INSTALLATION
 (1 END ONLY)

Figure 9a – Automatic Lid Opener Installation

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Revision: **A**
 Date: 10.03.10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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- 4.1.4. Locate the D3953-5 Gas Spring Stud as shown in Figure 8a. Trim Steel Mesh locally as required. Touch up paint per ICA-D350-607 Section 5.1 Item 4. Transfer Mark and Drill 2X Ø0.194 holes thru the Basket base square tube structure as shown in Detail L. Fasten D3953-5 IAW View N-N using 2X AN3C11A Bolt, 2X NAS1149C0332R Washer & 2X MS21043-3 Nut.
- 4.1.5. Install 1X D3953-11 Gas Spring Spacer onto the D3953-5 Stud as shown in View N-N. Install the large end of the D3969-1 Gas Spring onto the D3953-5 Gas Spring Stud and Fasten in Place using 1X D3953-9 Gas Spring Washer, 1X NAS1149C0432R Washer, 1X AN310-4 Castellated Nut & 1X MS24665-212 Cotter Pin as shown in View N-N. Install Cotter Pin per MS33540 or AC43.13 chapter 7-127.
- 4.1.6. Insert the D3953-3 Gas Spring Stud into the D3953-1 Gas Spring Bracket & Insert the D3953-7 Gas Spring Spacer onto the D3953-3 Gas Spring as Shown in View P-P. Raise the Basket lid and install the rod end of the D3969-1 Gas Spring onto the D3953-3 Gas Spring Stud using 1X D3953-9 Gas Spring Washer, 1X NAS1149C0432R Washer, 1X AN310-4 Castellated Nut & 1X MS24665-212 Cotter Pin as shown in View P-P. Install Cotter Pin Per MS33540 or AC43.13 Chapter 7-127.
NOTE: The D3953-3 Gas Spring Stud can be held in place with a 9/16 open end spanner/wrench.
NOTE: With the lid in the closed position the Gas Spring should not be fully compressed.
- 4.1.7. Repeat steps 4.1.2 through 4.1.6 at the other end of the Basket.
- 4.1.8. Test the installation. If installed properly the Gas Springs should assist the Basket user in both opening and closing the basket lid.

4.2 D350-607-143 AUTOMATIC LID OPENER INSTL (FOR USE ON -043/-047 BASKET)

NOTE: This kit may be installed at either end of the Basket. However, the Prop Arm must be removed in either case as it will interfere with the function of the Gas Spring.

- 4.2.1 Remove the D2332-041 Prop Arm.
- 4.2.2 Grind flush the D2327-3 Spacer Bushing on the end of the Basket where the lid opener is to be installed as shown in Figure 9a (it is permissible to grind all 4 spacers flush). Touch up paint per ICA-D350-607 Section 5.1 Item 4.
- 4.2.3 Locate the D3953-15 Gas Spring Bracket as shown in Figure 9a. Trim steel mesh locally as required. Touch up paint per ICA-D350-607 Section 5.1 Item 4. Transfer mark and drill 2X Ø0.194 holes thru the Basket Lid Square tube structure as shown in Detail R. Install the D3953-15 Gas Spring Bracket & D3953-17 Gas Spring Spacer using 2X AN3C15A BOLT, 2X NAS1149C0332R Washer & 2X MS21043-3 Nut as shown in View T-T.
- 4.2.4 Locate the D3953-5 Gas Spring Stud as shown in Figure 9a. Trim Steel Mesh Locally as required. Touch up paint per ICA-D350-607 Sections 5.1 Item 4. Transfer mark and drill 2X Ø 0.194 holes thru the Basket Base square tube structure as shown in Detail S. Install 2X AN3C11A Bolt, 2X NAS1149C0332R Washer & 2X MS21043-3 Nut as shown in View U-U. Install the rod end of the D3969-1 Gas Spring onto the D3953-5 Gas Spring Stud using 1X D3953-9 Gas Spring washer 1X NAS1149C0432R Washer, 1X AN310-4 Castellated Nut & 1X MS24665-212 Cotter Pin as shown in View U-U. Install Cotter Pin per MS33540 or AC43.13 Chapter 7-127.
- 4.2.5 Insert the D3953-3 Gas Spring Stud into the D3953-15 Gas Spring Bracket & insert the D3953-7 Gas Spring Spacer onto the D3953-3 Gas Spring Stud as shown in View T-T. Raise the Basket lid and install the D3969-1 Gas Spring onto the D3953-3 Gas Spring Stud and fasten in place using 1X D3953-9 Gas Spring Washer 1X NAS1149C0432R Washer, 1X AN310-4 Castellated Nut & 1X MS24665-212 Cotter Pin as shown in View T-T. Install Cotter Pin per MS33540 OR AC43.13 Chapter 7-127.
NOTE: The D3953-3 Gas Spring Stud can be held in place with a 9/16 open end spanner/wrench.
NOTE: With the lid in the closed position the Gas Spring should not be fully compressed.

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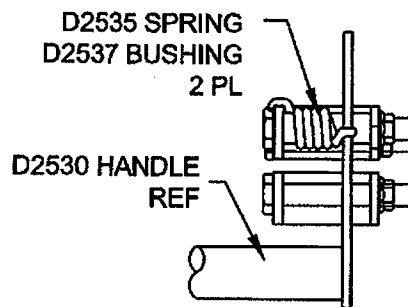
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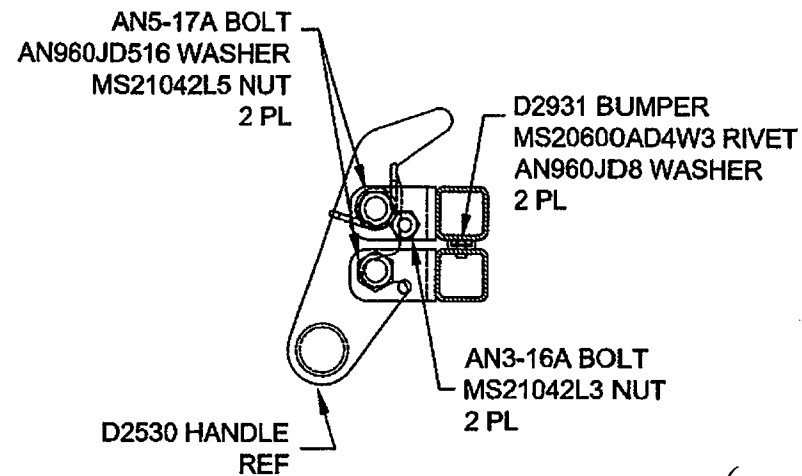
DART AEROSPACE LTD.

D350-607-1

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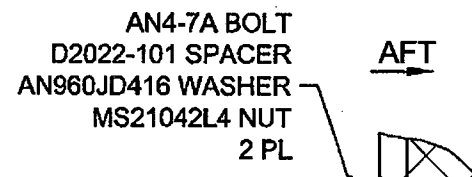
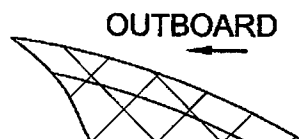


SPRING DETAIL



LATCH DETAIL

DETAIL J:
HANDLE WELDMENT



u/b 60849

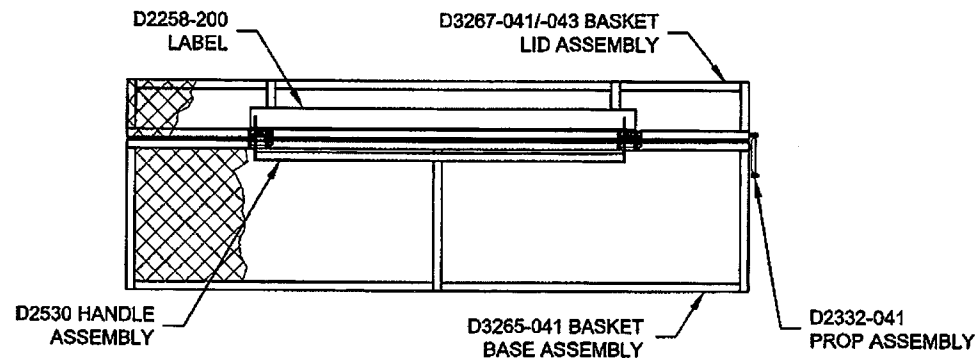
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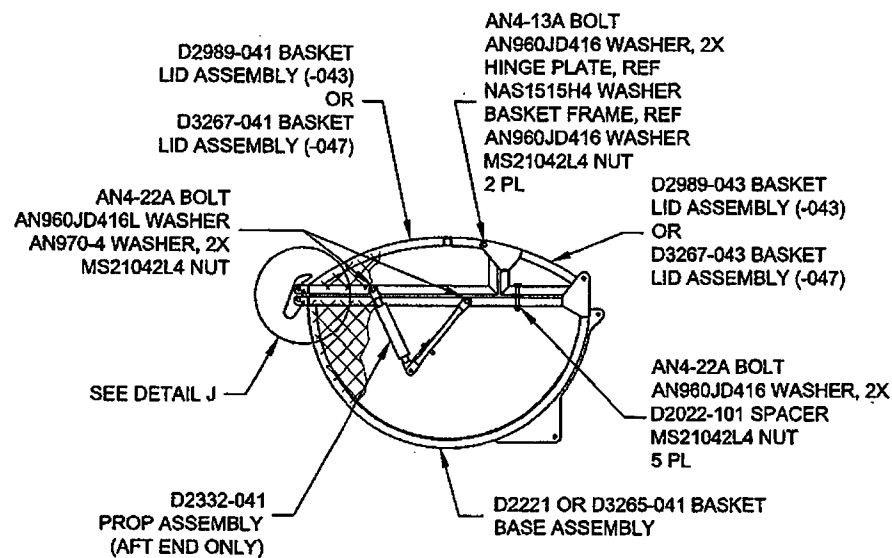
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D350-607-047 HELI-UTILITY- BASKET™



VIEW C-C
PROP ARM DETAIL

Figure 6– Basket Replacement Parts

W/60809

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

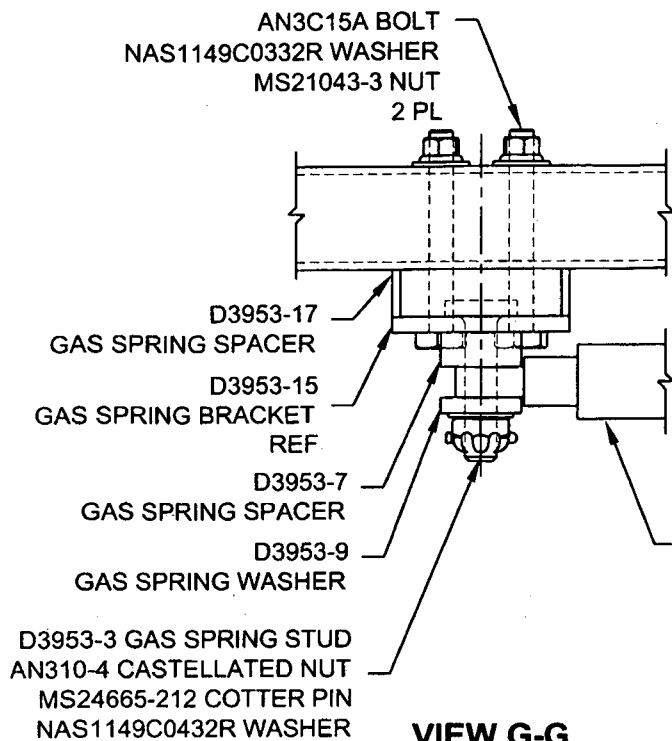
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

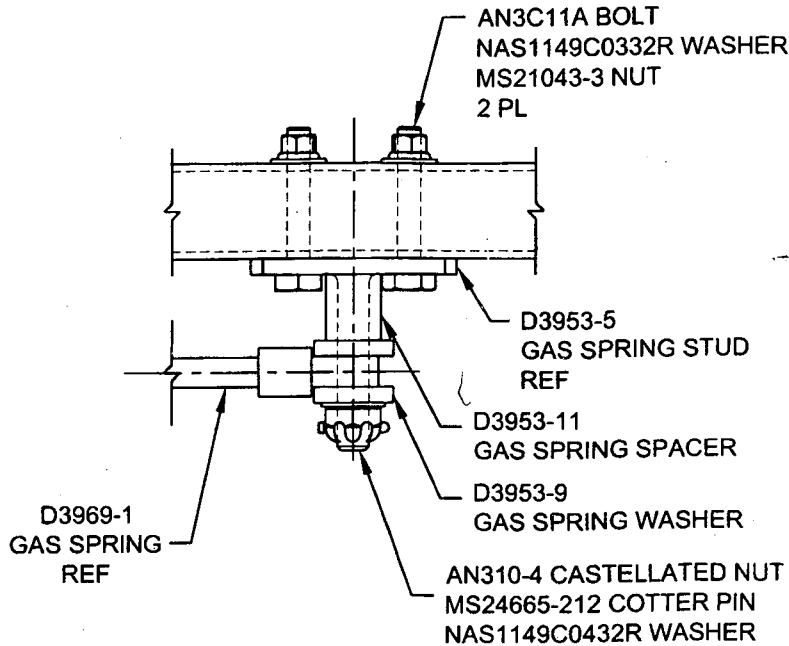
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

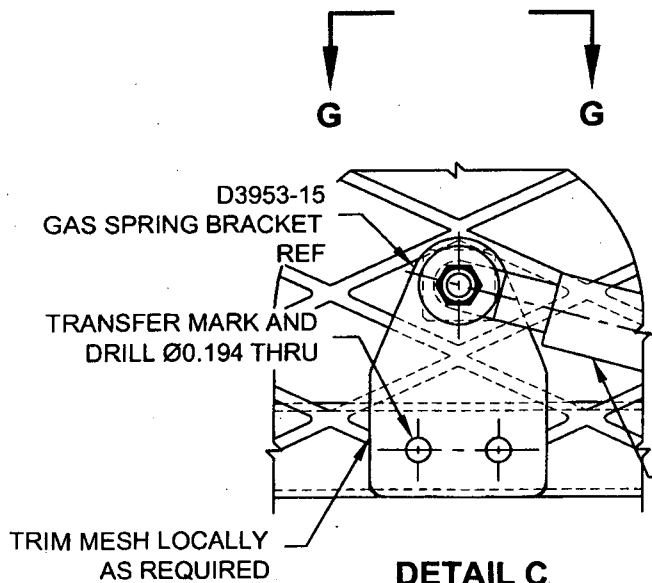
62854



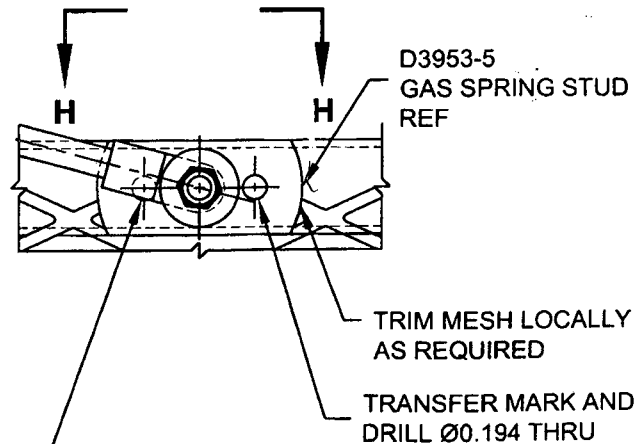
VIEW G-G



VIEW H-H



DETAIL C



DETAIL D

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 09.11.11
CERT. NO.: SH94-14
ISSUE NO.: 4

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.	N/A	DSI 9473	SHEET 8 OF 8
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	AUTOMATIC LID OPENER INSTL	NTS
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